

Work Order ID 72651

Thursday, August 04, 2011 7:07:12 AM

Page 1

Item ID: D4334-5

Accept

Setup Start

Revision ID:

Stop

Item Name: Pairing

Start Date: 8/3/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4334

A

100

0.00

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

xl

11/08/09

105

0.00

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: 340°F

Time IN: 4:30 pm

Time OUT: 7:00 am

11/08/08
11/08/09

xl

11/08/09

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Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00



Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA106 using tool DT9717
Dwg Rev: A
Folio Rev: A

X1

DL
11/08/09

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

X1

DL
11/08/09

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

X1

DL
11/08/09

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 HandThermo	Memo	0.00				xl			Wk 11/08/09
Hand Finishing Thermoforming	1-Trim to finished dimensions as per Dwg								
150 QC	QC2- Inspect parts off machine FAI/FAIB	0.00				xl			Wk 11/08/09
Quality Control	Memo Complete FAI document	0.00							
160 QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							8/10/09

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Item Name: Fairing

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Cust Item ID:

Required Date: 8/5/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

11/09

11/08/09

11-08-09

Picklist Print

Page 1

Thursday, August 04, 2011 7:07:09 AM

Work Order ID: 72651



Parent Item: D4334-5



Parent Item Name: Fairing

Start Date: 8/3/2011

Required Date: 8/5/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 11/04/01 DL verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	1,285.115	3.46875	3.651316			
GE PLASTICS LEXAN SHEET													

Location

MAT018

116236

Loc Qty

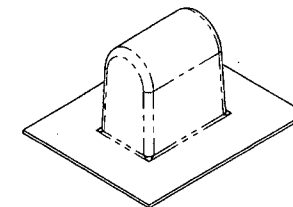
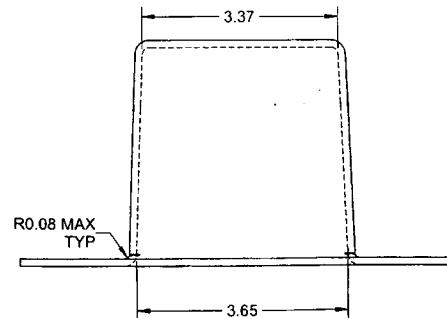
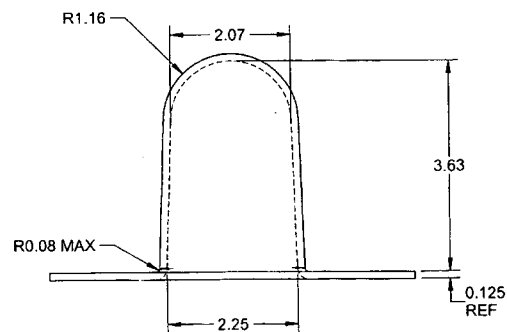
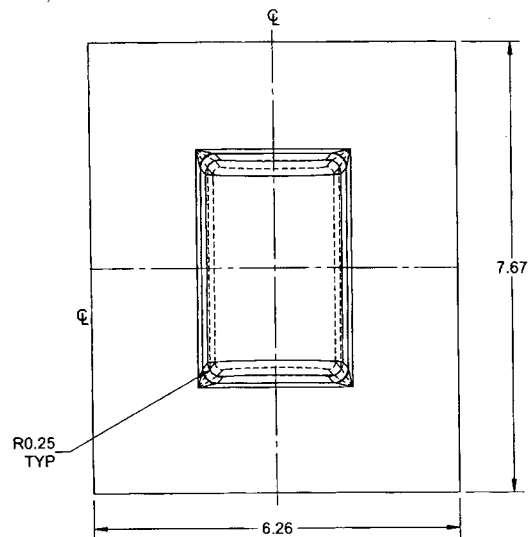
1285.115789

1285.11579

Loc Code

3.46875 sf A

W6
11/08/09



D4334-5 FAIRING

NOTES:

- 1) MATERIAL: F60029-GY3778 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK
REF DART SPEC MLEXS.125-F60029-04
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.34 lbs
- 8) THERMOFORM USING DT9717 MOULD

w/0 72651

RELEASED
2011-05-27

DESIGN	<i>DE</i>	DART AEROSPACE LTD	
DRAWN	<i>DE</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>DE</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>DE</i>	D4334	SHEET 6 OF 11
APPROVED	N/A	TITLE	SCALE
DE APPR.	N/A	BRACKET	NTS
DATE	11.04.18	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order: 72651
Description: FAIRING.		Part Number: D4334-5
Inspection Dwg: D4334-5 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DL</u>	Date: 11/08/09
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.67"	± 0.100	7.625"	✓		TAPER DL-01	} See Attached E-MAIL
6.26"	0.100	6.25"	✓		TAPER DL-01	
2.25"	0.100	2.28"	✓		Ven TH-01	
3.63"	0.100	3.62"	✓		Ven TH-01	
3.65"	0.100	3.66"	✓		Ven TH-01	
3.37"	0.100	3.30"	✓		Ven TH-01	

Measured by: <u>DL</u>	Date: 11/08/09
Audited by: <u>JB</u>	Date: 11/08/09
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14

Daryl Leger

From: Harvey Siemens <hsiemens@dartaero.com>
Sent: Tuesday, August 09, 2011 10:33 AM
To: Daryl Leger
Subject: D4334

Daryl

It is acceptable for the tolerances of D4334-5/-7 fairings to be 1 decimal place.

Regards,

Harvey Siemens

Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
E: hsiemens@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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